

DULUX®

FleetShield®

488 ULTRABUILD EPOXY PRIMER



Dulux Australia

ABN 67 000 049 427

Product Name:

488- Dulux® FleetShield® Ultrabuild Epoxy Primer

Product Description:

Dulux® FleetShield® ULTRABUILD Epoxy Primer is a two pack epoxy- polyamide primer that has excellent adhesion to metal substrates. Ultrabuild contains anti-corrosion pigmentation and has excellent water resistance.

Dulux® FleetShield® ULTRABUILD Epoxy Primer is easy to sand. The top coat may be applied after 2 hours without sanding at 20°C. The primer may be top coated with Autospeed and Fleetshield 2K products without sanding up to 5 days after application of the primer if the temperature is below 25°C. The primer will require sanding prior to application of a topcoat after five days.

Ultrabuild is not recommended for application in conditions where the temperature will fall below 5°C during curing.

Suitable Dulux® FleetShield® and AutoSpeed® top coats include:

- Dulux® FleetShield™ 2K 2:1 Mixed colour, 428 line
- Dulux® FleetShield™ 2K 2:1 White Base, 428S0204
- Dulux® FleetShield™ 2K 2:1 Black Base, 42889843
- Dulux® FleetShield™ 2K 2:1 Red Base, 428S0011
- Dulux® FleetShield™ 2K 2:1 Yellow Base, 428S0062
- Dulux® AutoSpeed® PT Basecoat (440-Line)
- Dulux® AutoSpeed® CV 2K 2:1 mixed colour (488-Line)

Substrates

All substrates must be thoroughly prepared and cleaned. For metal substrates, it is recommended that the surface be abrasive blasted or thoroughly sanded prior to the application of the primer. Polyester filler can be applied over sanded Ultrabuild, and Ultrabuild can be applied over polyester filler.

It is recommended that Dulux® AutoSpeed® Prepwash 965-89784 is used for cleaning and degreasing of surfaces.

Suitably prepared surfaces:

- Sound existing finishes
- Steel, Aluminium and galvanized surfaces
- Fibreglass
- ABS plastic
- Polyester filler

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Product & Additives:

Dulux® FleetShield® ULTRABUILD Epoxy Primer White Pt A 488-S0055
 Dulux® FleetShield® ULTRABUILD Epoxy Primer Black Pt A 488-S0056
 Dulux® FleetShield® ULTRABUILD Epoxy Primer Grey Pt A 488-S0057
 Dulux® FleetShield® ULTRABUILD Pt B 980-S0058
 Dulux® AutoSpeed® 2K Thinner- Normal 920-89292
 Dulux® AutoSpeed® RP Thinner 920-89819
 Dulux® AutoSpeed® 2K Thinner- Slow 920-89847
 Dulux® AutoSpeed® Prepwash 965-89784

Please select thinner for Ultrabuild using the table below.

Temperature degrees (C)	5-10	10-15	15-20	20-25	25-30	30-35
RP thinner, 920-89819			Small area only			
2K Thinner- Normal 920-89292						Small area only
2K Thinner- Slow 920-89847						

	Mixing Ratio	4 Parts 488-S Ultrabuild Part A by volume	
	Hardener	1 Part Ultrabuild Part B 980-S0058 by volume	
	Thinner	15-25% 920-89292 by volume, depending on application	
	Spray Viscosity DIN Cup 4 @ 25°C	25 seconds at 15% thinning	
	Gravity & Suction Feed	Fluid Tip: CONVENTIONAL: 1.4 – 1.8mm	Spraying Pressure: 350-450 kPa. Or refer to manufacturer's recommendations
	Pressure pot	CONVENTIONAL: 1.1 – 1.8mm	350-450 kPa. Or refer to manufacturer's recommendations
	Application	1 to 2 even coats for a dry film build of 60-80 micron	
	Air Flash	10 - 15 minutes air flash between coats at 25°C.	
	Baking/Drying	8 hours at 25°C 60 mins at 50°C	
	Sanding - Manual	Wet: P600 - P800 Grit	
	Sanding - Manual	Dry: P400 - P600 Grit	





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	Sanding - Mechanical	Dry: P400 - P600 Grit
	Spraying	Use air fed mask at all times. Refer applicable AS/NZS Standards
	Pot Life	When mixed, 6 hours at 25°C
	Topcoat time – non sand	Minimum 2 hours Maximum 5 days <i>*recommendation at temperatures at or above 20°C</i>

HBC Formulae

Ultrabuild White Part A 488-S0055 and Ultrabuild Black Part A 488-S0056 can be mixed to provide the HBC colours in the table below,

HBC colour	Ultrabuild White Part A 488-S0055 (Grams per litre)	Ultrabuild Black Part A 488-S0056 (Grams per litre)	Total (Grams per litre)
1	1759.00	-	1759.00
2	1580.45	158.04	1738.49
3	731.12	909.84	1640.96
4	264.56	1322.81	1587.37
5	-	1557.00	1557.00

Ready for use charts:

Weight Mixing Ratios for 488-Line Fleetshield Ultrabuild Primer

a. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance.

HBC	Part A	Part B	Thinner
1	100.00%	12.80%	10.66-17.76%
2		12.95%	10.78-17.96%
3		13.72%	11.43-19.05%
4		14.19%	11.81-19.68%
5		14.46%	12.04-20.07%

The quantity of thinner added can be varied to suit your spraying conditions.
See notes below regarding alternate thinners and hardener.

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b. Using an ordinary balance and adding by grams – 15% thinner.

Weight of Ultrabuild (Grams)	Volume of RFU Ultrabuild (ml)				
	100 mL	500 mL	1000 mL	2000 mL	4000 mL
HBC-1	122.37	611.83	1223.65	2447.30	4894.61
HBC-2	120.97	604.87	1209.74	2419.48	4838.96
HBC-3	114.16	570.78	1141.57	2283.13	4566.26
HBC-4	110.40	552.01	1104.03	2208.05	4416.11
HBC-5	108.31	541.57	1083.13	2166.26	4332.52
980S0058 Ultrabuild Part B	15.67	78.35	156.70	313.39	626.78
92089292 Autospeed 2K Thinner	11.70	58.50	117.00	234.00	468.00

* Please use thinner selection chart when choosing thinner.

c. Using an ordinary balance and adding by grams – 25% thinner.

Weight of Ultrabuild (Grams)	Volume of RFU Ultrabuild (ml)				
	100 mL	500 mL	1000 mL	2000 mL	4000 mL
HBC-1	112.57	562.86	1125.71	2251.43	4502.85
HBC-2	111.29	556.46	1112.91	2225.83	4451.65
HBC-3	105.02	525.09	1050.17	2100.34	4200.68
HBC-4	101.59	507.94	1015.87	2031.75	4063.50
HBC-5	99.64	498.22	996.44	1992.88	3985.75
980S0058 Ultrabuild Part B	14.42	72.09	144.18	288.37	576.74
92089292 Autospeed 2K Thinner	17.94	89.70	179.40	358.80	717.60

* Please use thinner selection chart when choosing thinner.

For safe handling:

Please refer to the Material Safety Data Sheet number: for this product before use.

In the event of an emergency contact: 1 800 033 111 (ALL HOURS) NZ 0800 734 6

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